

44

DART AEROSPACE LTD	Work Order:	21584
Description: Bearpaw Kit (48" x 19") 205/430	Part Number:	K10015
Dwg: D2521 Rev. H	Qty:	15 Kits
Ref: K10015 Rev. A; DSK086-6 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																								
1	DC	Issue Traveler Note: (1) K10015 Kit consists of Qty (2) D2521 Dwg not required	HJ	04.09.23	15																																								
2	DC	Photocopy bluefile: K10015 D205-564-011 D430-688-011 and create labels per PPP K10015 CHG002 (Bag Bluefiles separately)	HJ DA	04.10.13	15																																								
3	GA	Cut 2 blanks per (1) K10015 Kit Cut blank: 19.50" x 48.00" x 1.00" thick (+0.030/-0.000) per DSK086-6 Material: Black UHMW 1" (MUHMWB10) Batch: <u>M15926</u>	ML	04/10/27	15																																								
4	MV	Inspect material for defects or damage prior to machining	ML	04/10/27	15																																								
5	MV	Machine as per Folio FA222 and Dwg D2521 Identify as D2521	ML	04/10/27	15																																								
6	QC2	Inspect parts as they come off the CNC machine	ML	04/10/27	15																																								
7	MV	Deburr	ML	04/11/02	15																																								
8	MV	Form as per Dwg D2521 using bending Jig DT8328	ML	04/11/02	15																																								
9	QC8 & 5	Second inspection	SM	04/11/05	15																																								
10	KP	Pick: Packing Kit (Note: D2521 is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>8</td><td>D2182B055</td><td>Rubber Cushion</td><td>B21185</td></tr><tr><td>16</td><td>D2274</td><td>Radius Block</td><td>B21585</td></tr><tr><td>2</td><td>D2521</td><td>Bearpaw</td><td>B21584</td></tr><tr><td>16</td><td>D2529</td><td>Washer B20964B</td><td>B21587A</td></tr><tr><td>8</td><td>D2947</td><td>Clamp B11420B/B17747/B19106</td><td>B14883/B16839/B19991</td></tr><tr><td>16</td><td>AN4-15A</td><td>Bolt</td><td>M15321</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M15321</td></tr><tr><td>16</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	8	D2182B055	Rubber Cushion	B21185	16	D2274	Radius Block	B21585	2	D2521	Bearpaw	B21584	16	D2529	Washer B20964B	B21587A	8	D2947	Clamp B11420B/B17747/B19106	B14883/B16839/B19991	16	AN4-15A	Bolt	M15321	16	AN960JD416	Washer	M15321	16	MS21042L4	Nut (or -4)	M15020	1	Paperwork package from Step 2			ML	04-11-02	15
Qty	Part Number	Description	Batch																																										
8	D2182B055	Rubber Cushion	B21185																																										
16	D2274	Radius Block	B21585																																										
2	D2521	Bearpaw	B21584																																										
16	D2529	Washer B20964B	B21587A																																										
8	D2947	Clamp B11420B/B17747/B19106	B14883/B16839/B19991																																										
16	AN4-15A	Bolt	M15321																																										
16	AN960JD416	Washer	M15321																																										
16	MS21042L4	Nut (or -4)	M15020																																										
1	Paperwork package from Step 2																																												
11	QC4	Inspect Kit for 100% Completeness on the W/O	ML	04/11/04	15																																								
12	PK	Identify and pack for shipping as per PPP K10015 Rev. D	ML	04/11/08	15																																								
13	AC	Cost / part <u>367.50</u>	ML	04-11-09	15																																								
14	DC	Close W/O <u>371.82</u> Inspect Level 21	HJ	04.11.10	15																																								

Rev	Date	Change	Revised By	Approved
A	01.10.16	K10015 created for Bearpaw Kit (MPP 2164)	SM	
B	03.05.26	Reformat; Incorporated D2521	KJ/RF	
C	04.02.17	Tolerance added to Step 3	KJ/JLM	

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21584
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.000	+/-0.030	1.007	✓		Vern	
B	5.600	+/-0.030	5.599	✓		Vern	
C	11.500	+/-0.030	11.500	✓			
D	10.250	+/-0.010	10.250	✓			
E	13.250	+/-0.010	13.250	✓			
F	8.500	+/-0.010	8.500	✓			
G	22.125	+/-0.030	22.125	✓			
H	8.75	+/-0.010	8.750	✓			
I	44.500	+/-0.030	44.500	✓			
J	6.688	+/-0.030	6.688	✓			
K	5.625	+/-0.030	5.621	✓			
L	7.000	+/-0.030	7.000	✓			
M	5.000	+/-0.010	5.000	✓			
N	4.000	+/-0.030	3.996	✓			
O	6.625	+/-0.030	6.625	✓			
P	19.000	+/-0.030	19.000	✓			
Q	0.31 x 45°	+/-0.030	0.313 x 45°	✓			
R	0.19 x 45°	+/-0.030	0.196 x 45°	✓			
S	0.50 x 45°	+/-0.030	0.510 x 45°	✓			
T	0.38 x 45°	+/-0.030	0.370 x 45°	✓			
U	0.063 x 45°	+0.030/-0.010	0.065 x 45°	✓			
V	Ø0.260	+0.005/-0.000	Ø0.260	✓			
W	Ø0.93	+/-0.030	Ø0.927	✓			
X	0.30	+0.030/-0.010	0.304	✓			
Y	0.375	+/-0.010	0.385	✓			
Z	0.750	+/-0.030	0.745	✓			
AA	0.250	+/-0.010	0.244	✓			
AB	4.000	+/-0.030	3.997	✓			
AC	6.625	+/-0.030	6.625	✓			
AD	0.950	+0.030/-0.010	0.955	✓			
AE	0.375	+/-0.010	0.380	✓			
AF	3.399	+/-0.030	3.399	✓			
AG	6.625	+/-0.030	6.625	✓			

Measured by:	<i>mf</i>	Audited by:	<i>EP</i>	Prototype Approval:	N/A
Date:	04/10/27	Date:	04/10/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	<i>[Signature]</i>

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 23, 2004
10:35 am

Work Order No : 0021584
Project Name : K10015
Project For : WK444
Work Order Type : Main
Main WO Number :
House Part Number : *K10015
Description : Bearpaw Kit
Manufactured : Yes
Amount Req'd : 15
Amount Done : 0
Start Date : 09-23-04
Est Finish Date : 10-30-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00